Them 10	Work Order June-12-13 9:15:1.		A	*102	842*						Page 1
Approvals: Process Plan: Methods Date: Set Date: Stop Tooling: Date: Stop *NR7*	Item ID: D2 Revision ID: Item Name: Ra Start Date: 6/0 Required Date: 6/0	2224 appel Anchor 03/13 Start Qty: 4.90	*4* *4*	Accept	Cust Item I		100)* s	•	ıv.	S1* S2*
Draw Nbr Revision Nbr Revision Nbr Rev E Rev				-	1 - 7			R		1/1	R1* R2*
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		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	ct		Temperature/Cure
		Crimp/Kin	ık/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing		Weld
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Work Ord Jung-12-13 9:		02842		*102	R42*					Pag
Item ID:	= = D2224	<u> </u>		Accept	*N9000	40100	* Se	tup Star	t *N	IS1*
Revision ID:	B					, (Stop		 IS2*
Item Name:	Rappel Anci		* 4 *		C. Maria ID.				IX	137
Start Date: -Required-Date	6/03/13 e±6/11/13	Start Qty: 4.00 Rea'd Oty: 4.00_	*4* - *4*-		Cust Item ID: Customer:					
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Outsource process	- Anodize	Memo Issue P/O: <u>{</u>	205/ 8 Red Anodize	0.00 as per Dwg D2224 MIL-A-86	25 '					
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		n	0.14	0.00				n		!
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Packaging										

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					WORK ORDER NON	-CC	ONFO	RMANCE / UF	PDATE					AEROSPACE
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	Cracks			. —	Broken/Damage/Defect		Hardwa	'e			Part Incorre	•		Temperature/Cure
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June-12-15 9:15:12 AM

Work Order ID:

102842

Parent Item:

D2224

Parent Item Name:

Rappel Anchor

Start Date: 6/03/13

Required Date: 6/11/13

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:D02.04.23Add note for grain direction & inspect 8, 21NG

m ID	Purch	Item	Primary Location	Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
	Purchased	No		<u> </u>		f İ	2.9000		1			
			<u>Location</u>		Loc Oty	<u>Lo</u>	c Code		4-43	21	13-	07-0
			MAT 12558	84	2.9 2.9			<u>x (.</u>	43			
		· — - — - — —		Purchased No Location MAT	Purchased No	Purchased No Location Loc Oty MAT 2.9	Purchased No f Location Loc Oty Lo MAT 2.9	Purchased No f 2.9000 Location Loc Oty Loc Code MAT 2.9	Purchased No f 2.9000 Location Loc Oty Loc Code	Purchased No f 2.9000 1 Location Loc Oty Loc Code MAT 2.9	Purchased No f 2,9000 1 Location Loc Oty Loc Code MAT 2.9	Purchased No f 2.9000 1 Location Loc Oty Loc Code MAT 2.99

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Work Orde	er:				DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
	··· 				Rework	1		Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	lo.				Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
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	Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred	ct	Temperature/Cure
	Crimp/i	(ink/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Und	qualified	Part Lost/Mi	ssing	Weld
	Cuffs			<u> </u>	Contamination	L	Instruct	tions Incomplete/U	nclear	Part Moved	·	Wrong Stock Pulled
	Crushin	_			Countersink	L	Misalig	gned/off center		Positioned V	Vrong	
	Heat Tr			_	Cut Too Short		Mislabe	eled	L	Power Loss/	Surge	Other
		ion Strip in	Tube	<u> </u>	Drawing	igspace	Misrea					
	Marks/				Drill Holes	<u></u>	Off-set					
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	Wave/1	wist in Tul	be	- [Fit/Function		Out of !	Sequence				

DART AEROSPACE LTD	Work Order:	100842
Description: Rappel Anchor	Part Number:	D2224
Inspection Dwg: D2224 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

		X First Ar	ticle [Prot	totype	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.188	+/-0.010	.189			ver	27-4
0.050 x 45°	+/-0.010 x 0.5°	.058		, ,		
0.250	+/-0.010	.253	-			
R0.500	+/-0.010	.500	سن ا			-
3.000	+/-0.010	3,001		-		
Ø0.507	+0.008/-0.001	,508			_	
0.750	+/-0.010	.748				
2.313	+/-0.010	2.314	س			
1.687	+/-0.010	(.686	<i></i>			
2.438	+/-0.010	2.438		,		
1.125	+/-0.010	1.123				
Ø0.313	+0.006/-0.001	3				
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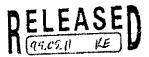
Measured by: 2 02	Audited by:	Onl	Prototype Approval:	N/A
Date: 13 0 2 06	Date:	13/08/0X	Date:	N/A

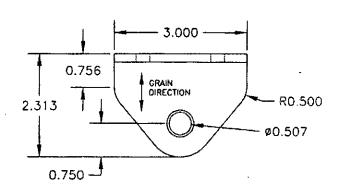
	Rev	Date	Change	Revised by	Approved
L	Α	08.04.11	New Issue	KJ/DD A	13/
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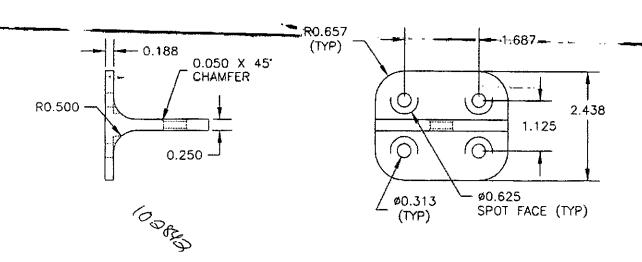
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QA Closed:			Date:							W	ork Order ut	odate only	
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	-					Rework	1		Skid-tube Crosstub	و٢	7	Water Jet	Engineering
Part N	lo.					Scrap			Machining Small Fa	-	Pro	d. Eng. Coor.	Quality
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	-	Cuffs	,	,	<u></u>	Contamination		1 `	tions Incomplete/Unclear		Part Moved	. -	Wrong Stock Pulled
	_	Crushing				Countersink		4	gned/off center		Positioned V	∟∟ Vrong	J *** 5118 5155K * 61166
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DESIG	12	RF	DART AEROSPACE LTD	₹.
	7 /4		HAWKESBURY, ONTARIO, CANADA	•
CHEC	سسم (۱۶	APPROVED	DRAWING NO.	REV. E
<u>L</u>	4E	#4-	D2224 SHEET	1 0F 1
DATE	<u> </u>		TITLE	SCALE
99.0)4.2 9		RAPPEL ANCHOR	1:2
Α		94.03.10	NEW ISSUE	
В		95.04.11	D2227 WAS D2216	
С		96.06.17	ADDED D2224-60	
D		97.04.25	CHANGE TO T-SHAPE	
ε		99.04.29	REVISE MATERIAL SPECIFICATIONS	







MATERIAL: 7075-T7351 (QQ-A-200/11) OR 7075-T651 (QQ-A-200/11)

FINISH : ANODIZE RED PER MIL-A-8625

BREAK ALL UNMARKED EDGES 0.010 TO 0.020

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DQA:		Date:			•			. هـي			ΔP
QA Closed:		Date:			WORK ORDER NON	-CONF	ORMANCE /	•	Vork Order u	ndate only	AEROSPACI
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Work Order:		•			DISPOSITION		•	AGAINST D	PEPARTMENT	/PROCESS	
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NCR No.	^				Use-as-is Suspected Unapproved	Th	ermoforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root				· Desc	ription of work order update	Initia	ıl A	Action	Sign &	<u> </u>	
Cause:	Date	Step	Qty		or non-conformance	Chief E	ing Des	scription	Date	Verification	QC Inspector
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Equip/Tooling	<u> </u>										
Handling/Pre					p - 1 4	₩			10 (m) 10 (m)		
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Landing	Gear		,		General	-					
	Bending				Bend	Foli	o/Program	ſ	Outside Dim	ensions	Pressure/Forced
	Centre No	ot Concer	ntric		BOM/Route	Gra	-		Over/Under	tolerance	Set-up
	Cracks				Broken/Damage/Defect	Hard	dware		Part Incorre	⊢	Temperature/Cure
	Crimp/Kink/Ripple/Wave		· - · - ·		ection Incomplete/	Unqualified	Part Lost/Missing		Weld		
	Cuffs			Contamination	-	Instructions Incomplete/Unclear		⊣ <u> </u>		Wrong Stock Pulled	
	· Crushing				Countersink	⊢ ⊣	Misaligned/off center			Positioned Wrong	
<u> </u>	Heat Treat			Cut Too Short	$\overline{}$	Mislabeled		—		Other	
Inspection Strip in Tube			Drawing		Misread			U			
,	Marks/Chatter			Drill Holes	\blacksquare	Off-set		 .			
					Finish *		Out of Calibration				
· †	Wave/Twist in Tube			-	Fit/Function	Out of Sequence					
	 -) Povit		1_1000	I I				



A.T.G. Industries Inc. 731, rue Industrielle Rd. PLATING DEPARTMENT Rockland, On K4K 1T2 Canada

Ph: (613) 446-4544 Fax: (613) 446-4556

Pack List

Number: 62520

Date: 22-Jul-13

To

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 Canada Ship To

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-520	00 Fax: 613-632-1185		13-032-0200		
Terms		Ship Via			
Quantity	Description		Rev:		
. 1	Part: ASST		1101.		
Jet	6 PCS D2224 RED ANODIZE MIL-A-8625 TYPE II CLASS 2				
	1			·	
	BLUE ANODIZE MIL-A-8625 TYPE II CLASS 2				
	2 PCS D4410-043 BLACK ANODIZE MIL-A-8625 TYPE II CLASS 2	· • ·	-	****	-
	10 PCS 646.3311 9 PCS 647.9315 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2				
	PRIME MIL-P-23377J TYPE I C Job: 20130455	CLASS N PO: 20518	Line:		
	•	f Conformance	•		
	A.T.G. Industries certifies that all it with all requirements, specification	ems in this shipment are in co s and drawings referenced in	informance the purchase order.		
	ISO 9001 : 2008 ATG SALES-20	REGISTERED 10 TERMS APPLY			
	CERTIFIED SIGNATURE:	w			
	CER (IFIED SIGNAL ONE . Z				
	RECEIVER SIGNATURE :				
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